

Date: Tuesday, 3/11/2008 7:57:10 AM
User: Kim Johnston

Process Sheet

SPUT

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AVIONICS RISER CONSOLE
Job Number : 37738
Estimate Number : 10259
P.O. Number :
This Issue : 3/11/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 37045
Written By :
Checked & Approved By : AD 03 11
Comment : Est Rev:B 05.04.11 Now made at Dart KJ/JLM
Est Rev:C 07-06-09 Holes now Transfer drilled JLM

Part Number : D212722011
Drawing Number : D3363 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 4/7/2008 Qty: 9 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

001.5/22 * 08.4.15 JLD

2.0 M6063T5A0750W063 Angle 6063T5X.75X.75X.063



Comment: Qty.: 7.2450 f(s)/Unit Total: 28.9800 f(s) 65.205

Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063)

Batch: M107435 107983 - 23200 FF 08-04-10

M107711 42
M107711 42

3.0 M6063T5C75X75W125 6063 CHANNEL 75X.75X.125



Comment: Qty.: 0.8290 f(s)/Unit Total: 3.3460 f(s) 7.461

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)

Batch: M107435 FF 08-04-10

4.0 D33631 CONSOLE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: 9.000 FF

Qty Part Number Description Batch
1 D3363-1 Console (Bent) B38263

FF 08-04-24 (9)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum
angle 3/4" x 3/4" x 0.063" wall

08-04-10
FF 08-04-10 (9)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 37738

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

FF 08-04-24 (9)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-24 (9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/04/24 (9)

8.0

PR351

DZUS FASTENER RAIL



Comment: Qty.: 0.3333 f(s)/Unit Total: 1.3332 f(s)

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: 117763 x 17 / m107913 x 1

FF 08-04-24 (9)

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total: 176.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS20426AD4-5

Rivet

3459

FF 08-04-24 (9)

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 MS20426AD4-6

Rivet

105144

FF 08-04-24 (9)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail

FF 08-04-24 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 37738

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description:

Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.

2-Rivet D3360-1/3/5 & D3361-1 & D3362-1 as per Dwg D3363
Identify as D3363-041

FF 08-04-29

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/05/15 (F)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

14.0

PFSC3538A

Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 PFSC35-38A

Dzus Fastener

1 d3363-041

Console Ass

72

M107014 x24

37738

There is 8.
M19567x8

AS 08/05/15 (F)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/05/22 (F)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

0 08/05/22 (F)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22 (F)

Job Completion



mf 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

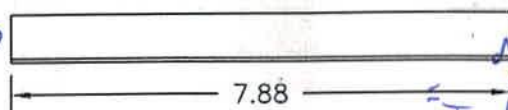
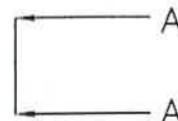
DART

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CHECKED PH	APPROVED PH	DRAWING NO. D3360	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

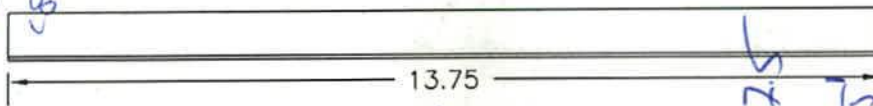
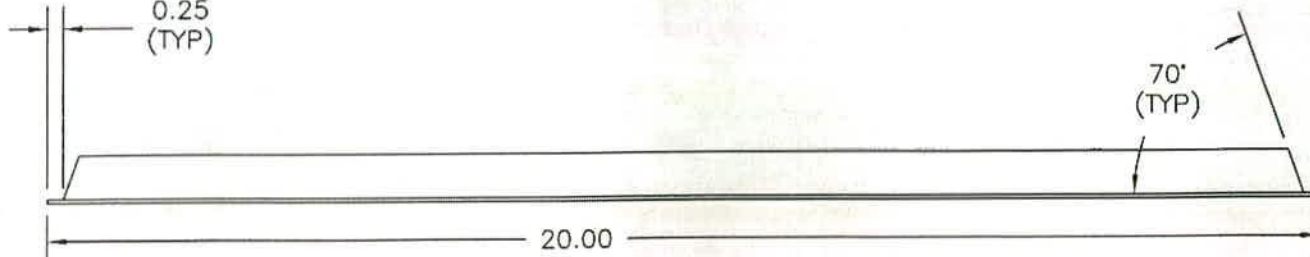
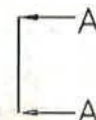
RELEASED

05-03-31

242/16

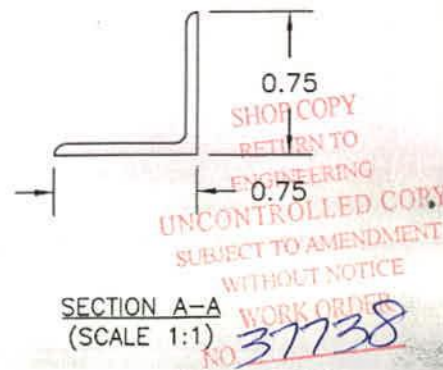
D3360-1
(SCALE 1:3)

242/16

D3360-3
(SCALE 1:3)0.25
(TYP)D3360-5
(SCALE 1:3)

D3360-1/-3/-5 ANGLE

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

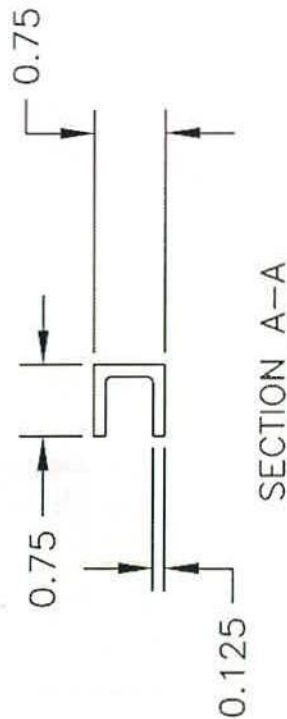
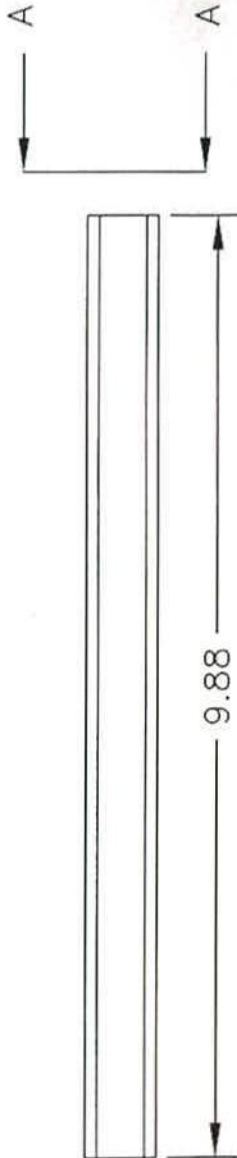
SECTION A-A
(SCALE 1:1)

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DATE 04.11.29	TITLE CHANNEL		SCALE 1:2
A	04.11.29	NEW ISSUE	

**RELEASED**

05-0331

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D3361-1 CHANNEL

1) CUT LENGTH/SHAPE PER DIAGRAM

2) MATERIAL: 6063-T52 ALUMINUM

STOCK SIZE: 3/4" x 3/4" x 0.125" CHANNEL EXTRUSION

3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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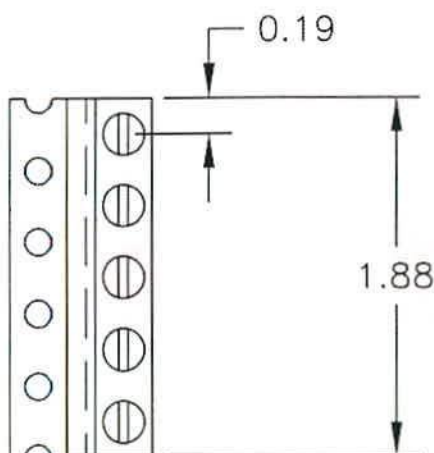
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DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

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05.03.31 [Signature]



D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

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DART**DART AEROSPACE LTD**
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REV. C

SHEET 1 OF 3

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D3363

DATE

07.01.26

TITLE

CONSOLE ASSEMBLY

SCALE

1:5

A

04.11.29

NEW ISSUE

B

05.03.28

INCREASE WIDTH BY 0.125

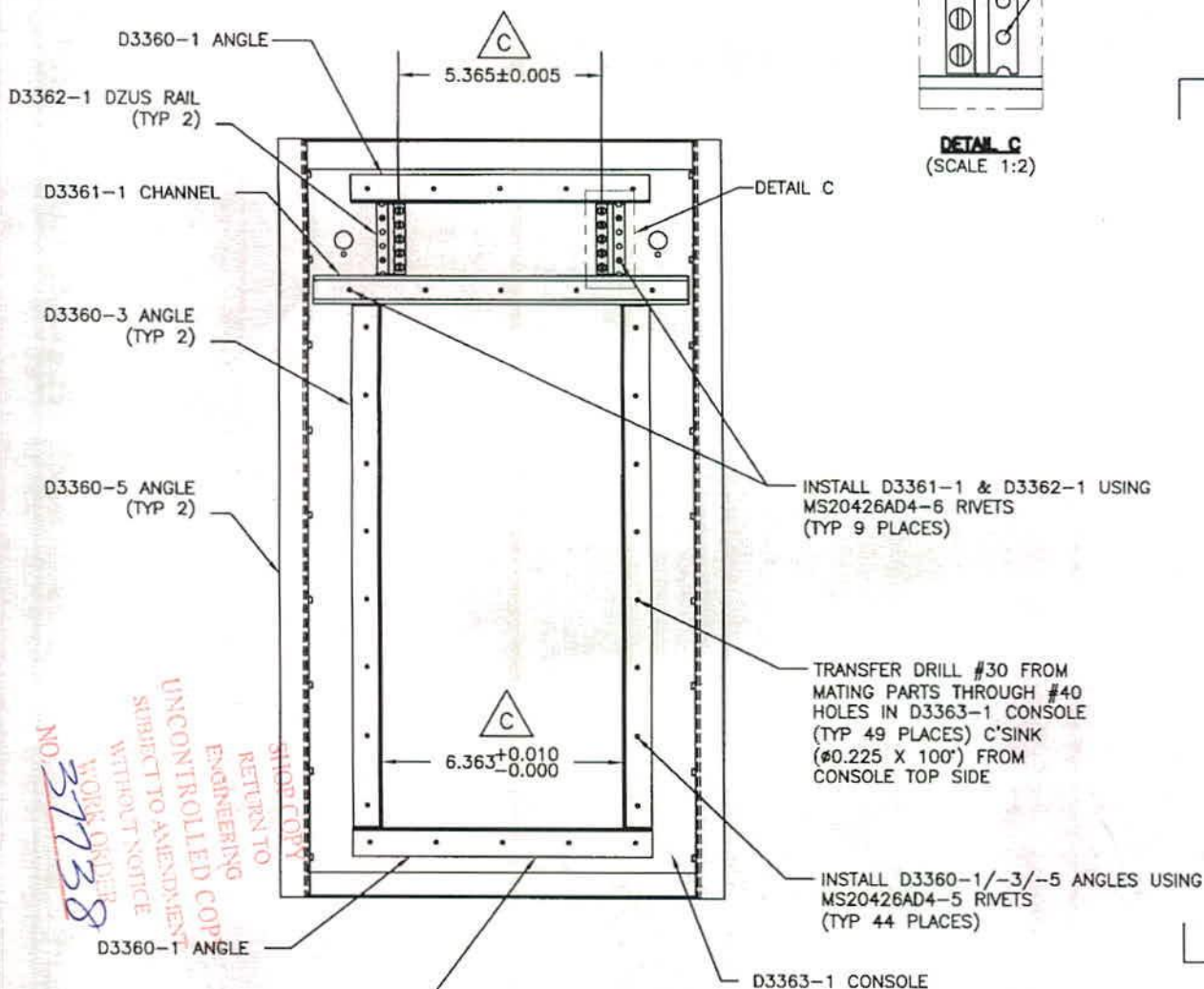
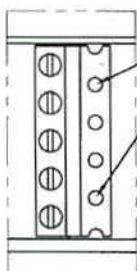
C

07.01.26

T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL
THROUGH D3363-1 CONSOLE (TYP 4 PLACES)
C'SINK (#0.225 X 100")
FROM TOP SIDE OF CONSOLE**DETAIL C**
(SCALE 1:2)**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY**

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

VIEW A-A FROM UNDER CONSOLE ASSEMBLY**D3363-041 CONSOLE ASSEMBLY**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

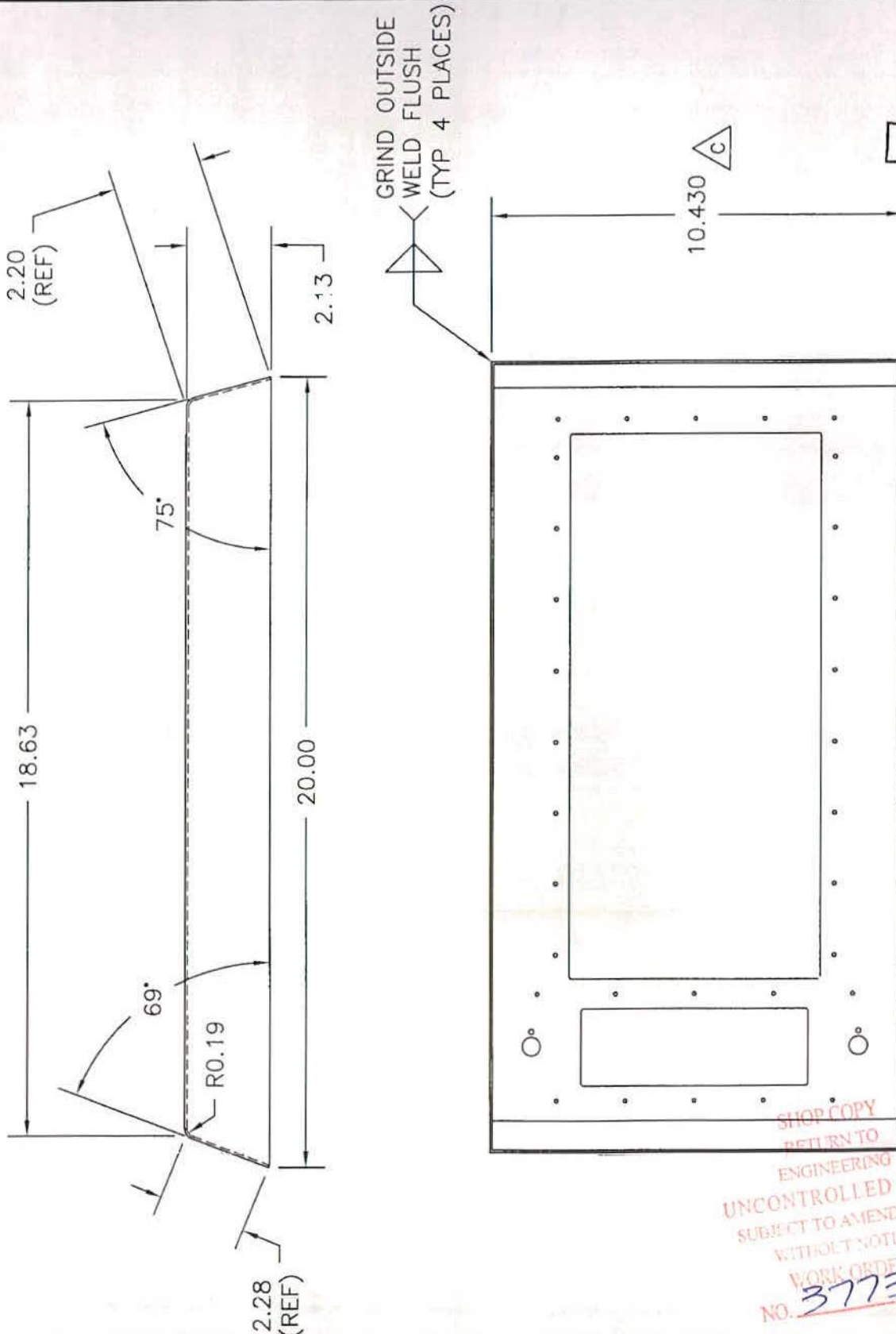
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4

**RELEASED**07.06.04 *PH***D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

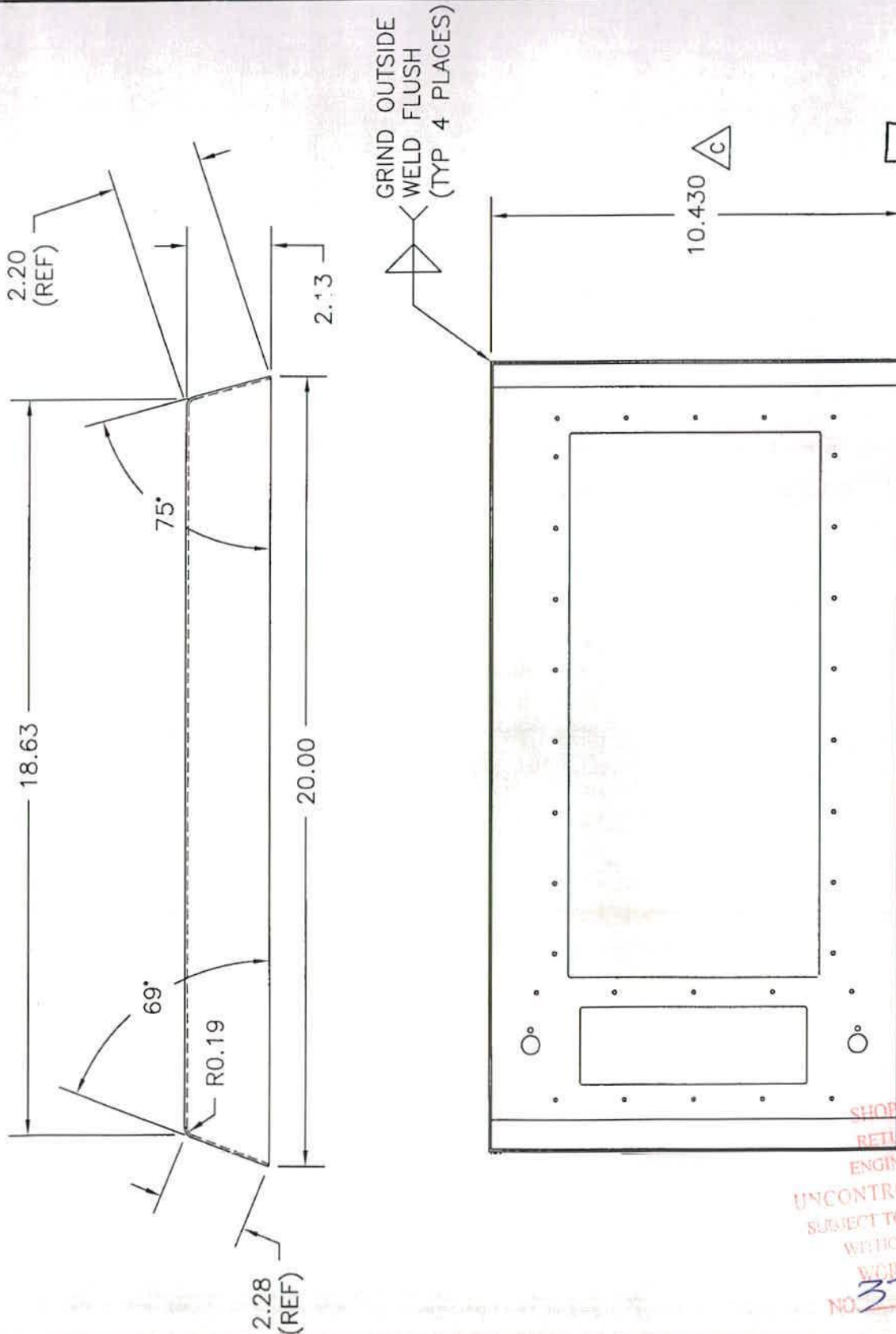
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

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D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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